

Work Order ID 80281

February-16-12 10:26:36 AM

80281

Page 1

Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube Assembly
 Start Date: 16/02/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 01/03/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 12/02/16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								

100

100

Mori Seiki

Mori Seiki CNC Lathe Large

MORI SEIKI CNC LATHE LARGE

Memo

Turn as per Folio FA599 Rev: AA & Dwg D3391 Rev: I

scribe batch # on fwd end at 90 degree

0.00

0.00

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

111

111

QC

Quality Control

QC8- Inspect parts - second check

Memo

INSPECT INSIDE BORE

0.00

0.00

1 φ
mm 12/03/19

1 φ
mm 12/03/19

1 φ
mm 12/03/19

36
 12/03/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 Memo 1-Machine as per Folio FA 599 Rev: <u>AA</u> & Dwg D3391 Rev: <u>I</u> 2-Deburr	0.00 0.00				1	0		<u>mant</u> 12/03/14 21
130 *130* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				1	0		<u>mant</u> 12/03/14 21
140 *140* QC Quality Control	QC8- Inspect parts - second check Memo ***INSPECT INSIDE BORE***	0.00 0.00				1	0		DA 12/03/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803								
160		0.00							
160	BENDING MACHINE - SKIDTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Form as per Dwg D3391 Using Bend Prog 3391025								
170		0.00							
	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							
Quality Control									

CF 12.3.27

DC 12/03/27

DP 12-3-27

4.08

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Tube Assembly

Start Date: 16/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 01/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

0.00

180

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217
Wearplate Jig.

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe, wearplate to 0.297"and float bag holes to 0.328" as per
Dwg D3391.

7-Deburr

DL 12/04/04

CC 12/04/11

DL 12/04/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
200 *200* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
210 *210* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

8.7/4/24

2/6 12.4.26

① SMO 05-04-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	Skidtubes	0.00							
220									
Skidtubes	Memo	0.00							
Skidtubes	Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: <u>121221</u> exp. date: <u>13/01/04</u> cure time 12hrs as per QSI0015								
230	QC5- Inspect part completeness to step on W/O	0.00							
230									
QC	Memo	0.00							
Quality Control									
235	Pressure Wash per QSI005 4.3	0.00							
235									
HandFinish	Memo	0.00							
Hand Finishing	AND REALODINE AS PER PAR09-043								

- DC 12/04/26

81210507

12-58

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Required Date: 01/03/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 *240* Powdercoat Powder Coating <i>W121134</i>	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: <i>9:15</i> OVEN TEMPERATURE: <i>320°F</i> FINISH TIME: <i>9:45</i>	0.00 0.00				<i>IX</i>	<i>Ø</i>		<i>ML 12/05/08</i>
250 *250* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>IX</i>	<i>Ø</i>		<i>ML 12/05/10</i>
260 *260* HandFinish Hand Finishing	HandFinishing Memo 1-Install inserts as per Dwg D3391 2-Install Aft Cap as per Dwg D3391 A/ R Sikaflex-241/-291 <i>M121221</i> Sikaflex expiry date: <i>13/05</i> 3- INSTALL WEARPLATES AS PER DWG	0.00 0.00				<i>IX</i>	<i>Ø</i>		<i>ML 12/05/10</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item ID: D3391-025

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Tube Assembly

Start Date: 16/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 01/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	QC5- Inspect part completeness to step on W/O	0.00							
270									
QC	Memo	0.00							
Quality Control									
280	Identify as per dwg & Stock Location: _____	0.00							
280									
Packaging	Memo	0.00							
Packaging									
290	QC21- Final Inspection - Work Order Release	0.00							
290									
QC	Memo	0.00							
Quality Control									

MJ 12/05/16

MF
12-05-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 80281

80281

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 16/02/2012

Required Date: 01/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H
 11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	----------------	--------------	---------------	----------------	--------

D4095-047		Manufactured	No			260	Each	16.0000	1	1			
D4095-047													
Wearpad Assembly													
**													
JL 12/05/10													

Location	Loc Qty	Loc Code
FP001	4	
77435	4	B80703
FP002	12	
78325	12	

D4095-049		Manufactured	No			260	Each	11.0000	1	1			
D4095-049													
Wearpad Assembly													
**													
JL 12/05/10													

Location	Loc Qty	Loc Code
FP002	11	
76538	4	B81612
77436	7	

D6014-090		Manufactured	No			100	Each	0.0000	1	1			
D6014-090													
ALUMINUM EXTRUSION													
**													

77332

1 man. 12/03/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 80281

80281

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 16/02/2012

Required Date: 01/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

230

Each

99.0000

4 4

D3670-4-200

SPACER

**

12/04/26

Location

Loc Qty

Loc Code

LG001

99

72851

7

77500

32

78606

60

D2646

Manufactured No

270

Each

107.0000

1

D2646

Aft Cap

**

12/05/10

Location

Loc Qty

Loc Code

FP002

107

62678

5

68280

5

70945

1

71070

2

73294

1

73825

43

78018

50

D3672-1

Manufactured No

270

Each

924.0000

2

D3672-1

Phenolic Washer

**

12/05/10

Location

Loc Qty

Loc Code

FP001

288

66821

288

ST060

636

72229

136

76277

500

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Aft Tube Assembly

80281

D3391-025

Start Date: 16/02/2012

Required Date: 01/03/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

260

Each

2,115.000

14

14

AI S4-1032-130

Insert

yl 12/05/10

Location

Loc Qty

Loc Code

ST280

1116

1120837

x14

119084

116

120671

1000

ST281

999

119632

19

120410

980

ALS4-1032-225

Purchased

No

270

Each

1,382.000

8

8

AI S4-1032-225

Insert

yl 12/05/10

Location

Loc Qty

Loc Code

ST281

1031

108696

146

110768

62

118386

55

118966

68

120671

700

ST282

351

11121269

x8

120410

200

120451

151

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Aft Tube Assembly

Start Date: 16/02/2012

Required Date: 01/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

270

Each

3,439.000

6

6

AN3C4A

BOLT

**

HL 12/05/10

Location

Loc Qty

Loc Code

ST350

3439

117313

2

117688

5

117872

10

118112

16

118451

2

119749

10

120187

2000

120423

394

120521

1000

x6

AN3C5A

Purchased

No

270

Each

1,038.000

4

4

AN3C5A

Bolt

**

HL 12/05/10

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1031

116419

28

117343

13

117764

7

117872

2

119127

24

119749

27

120423

930

M12144d

x4

AN960C10L

NAS1149C0332

Purchased

No

270

Each

0.0000

10

10

*AN960C10I * ✓

washer

M121509

**

(x10) HL 12/05/10

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Shop Packet Print

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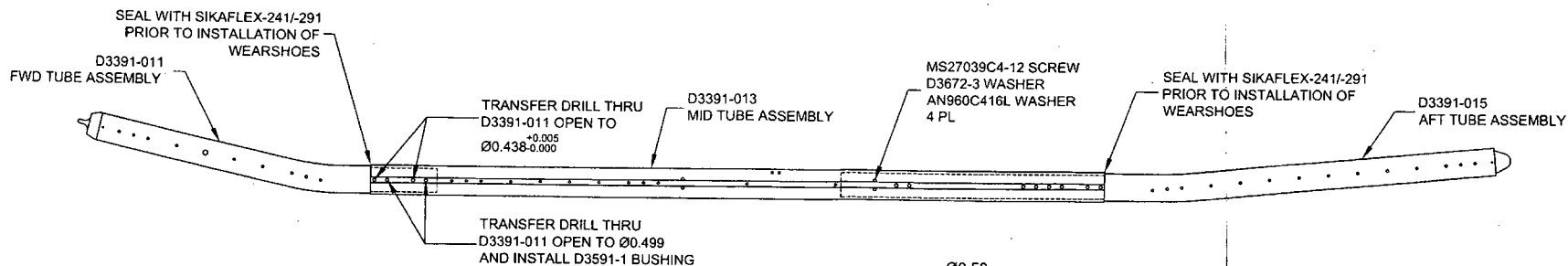
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D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 80281 MCT
12/02/10

RELEASED
2011-11-04
ECN# 11-662

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A8-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D3391	SHEET 1 OF 8
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DE APPR.		412 FLOAT SKIDTUBE	NTS
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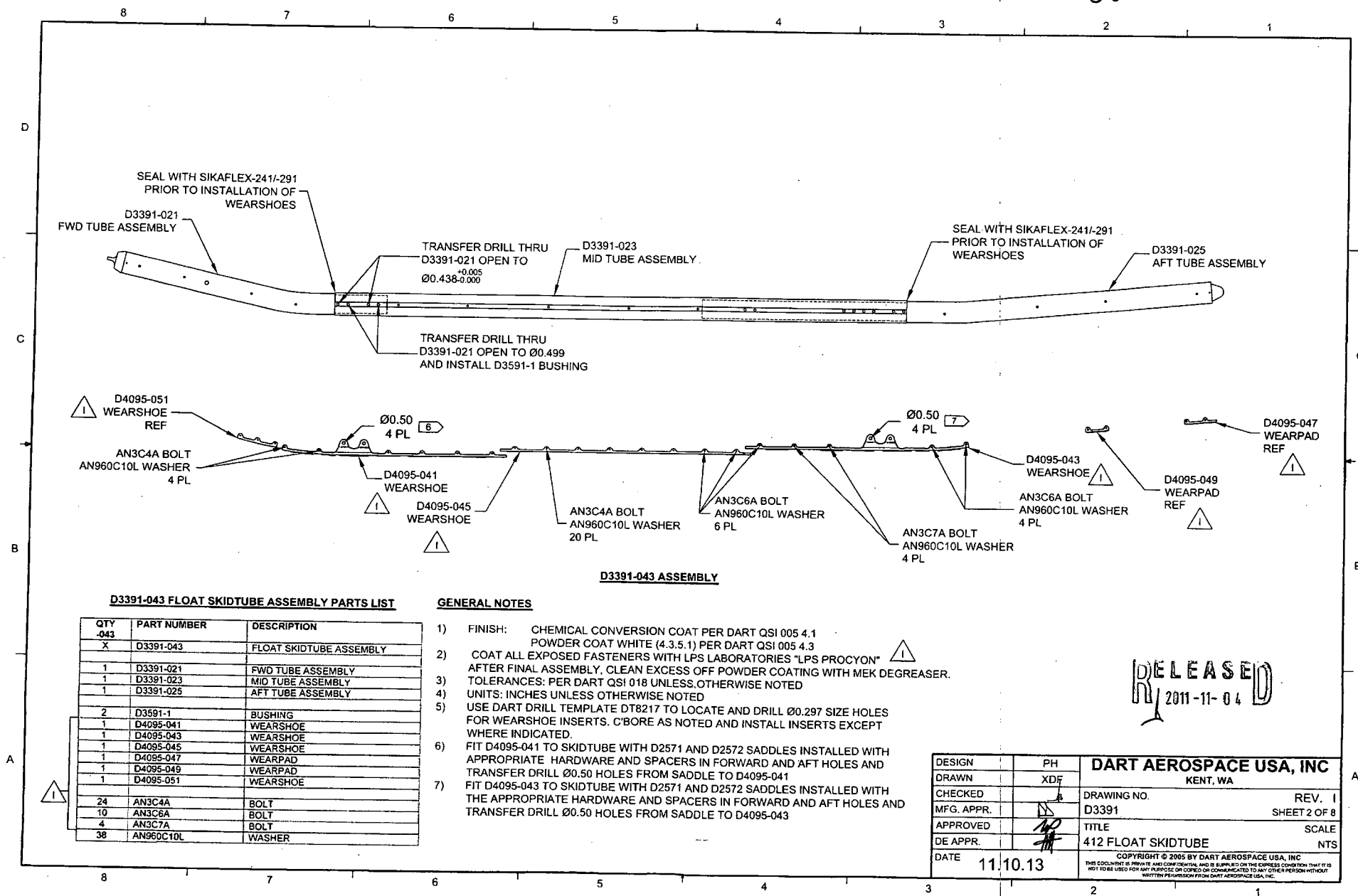
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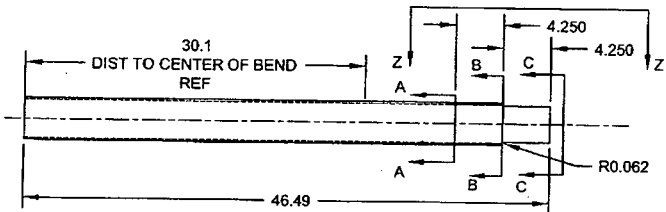
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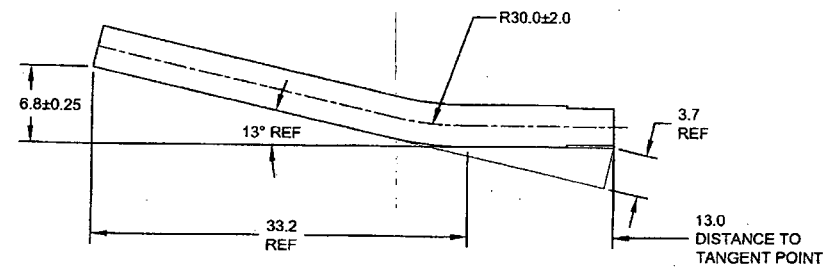
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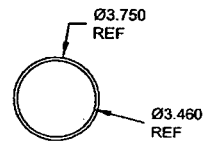
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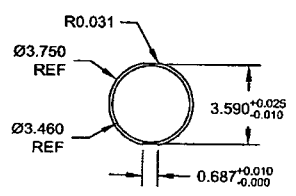
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



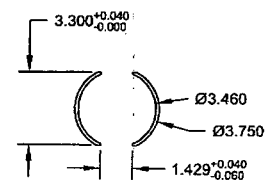
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



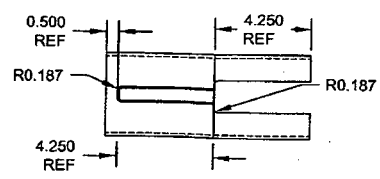
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

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2011-11-04

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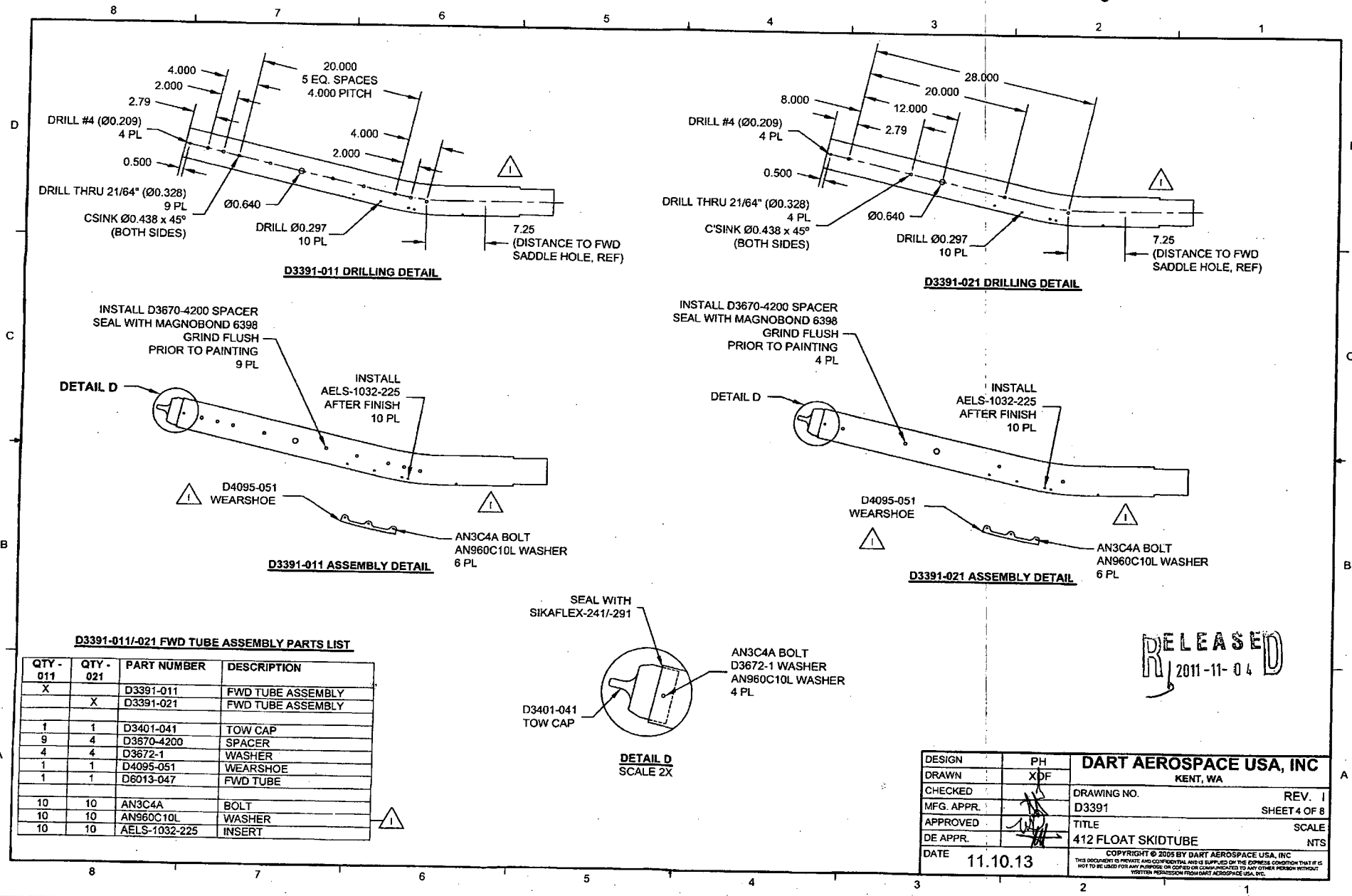
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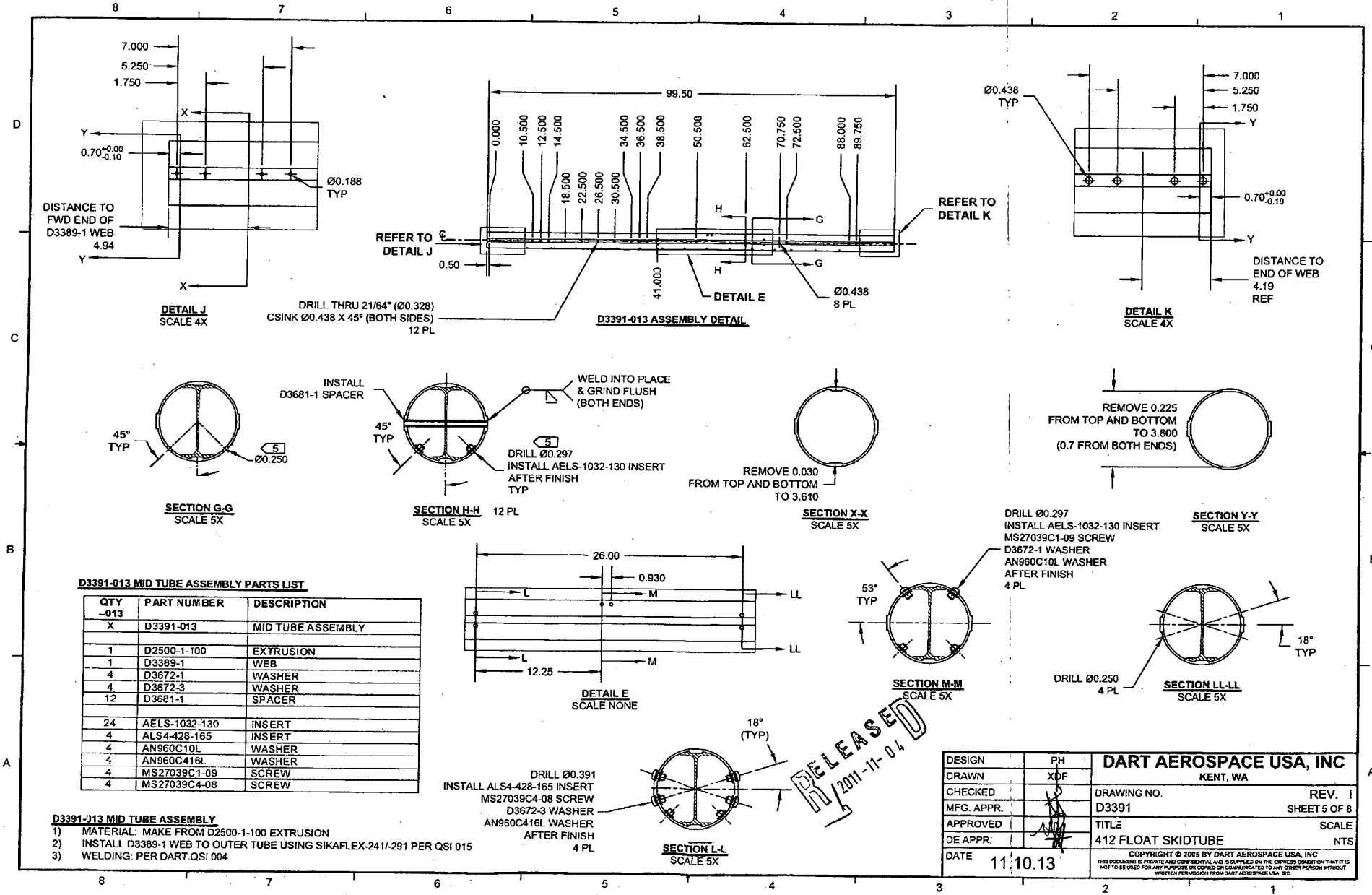
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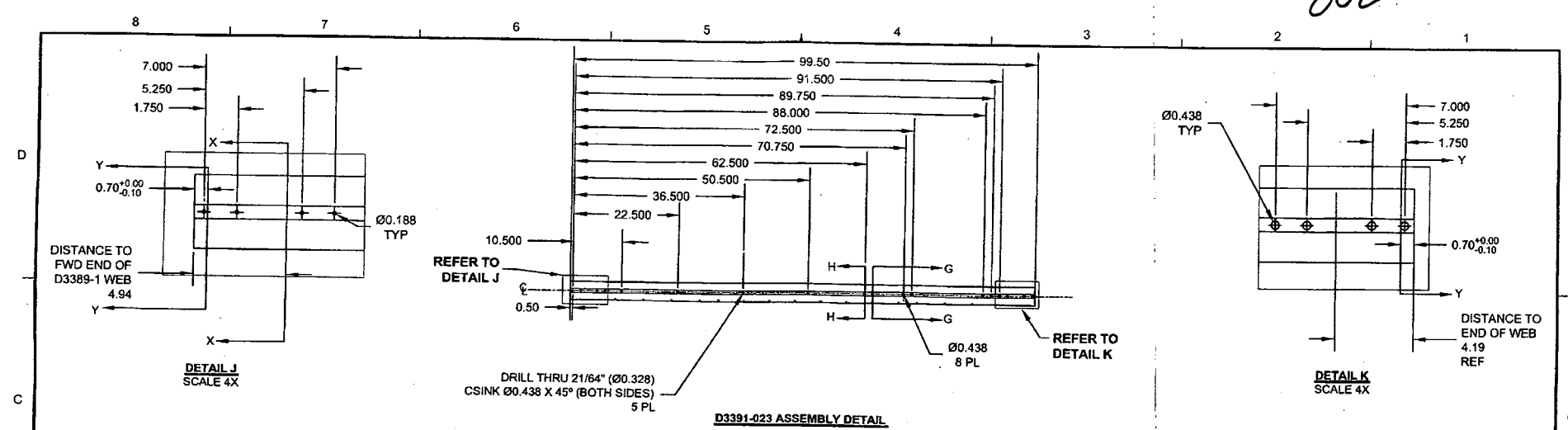
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D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY -	PART NUMBER	DESCRIPTION
023		
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

- D3391-023 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
 - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
 - 3) WELDING: PER DART QSI 004

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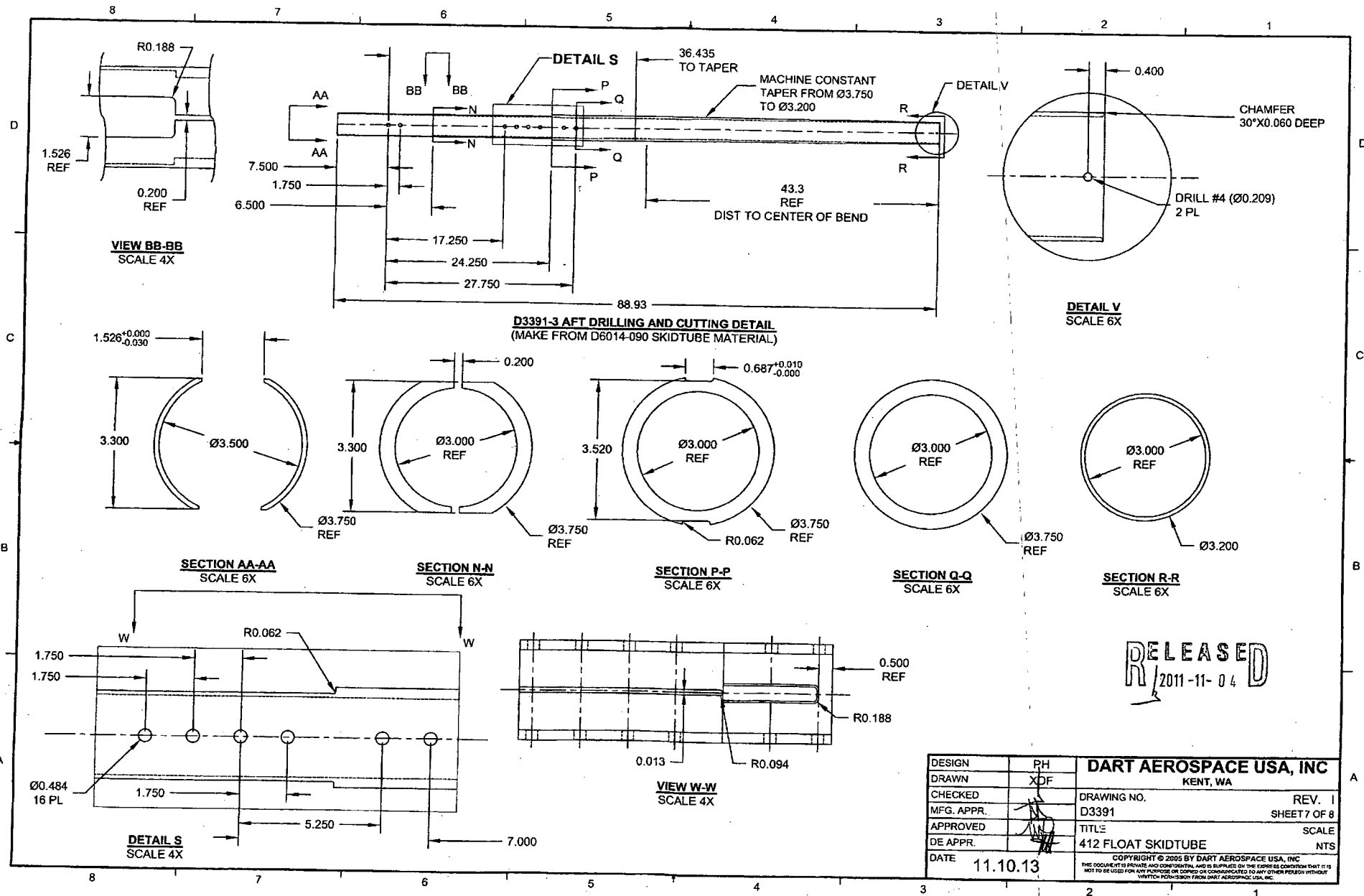
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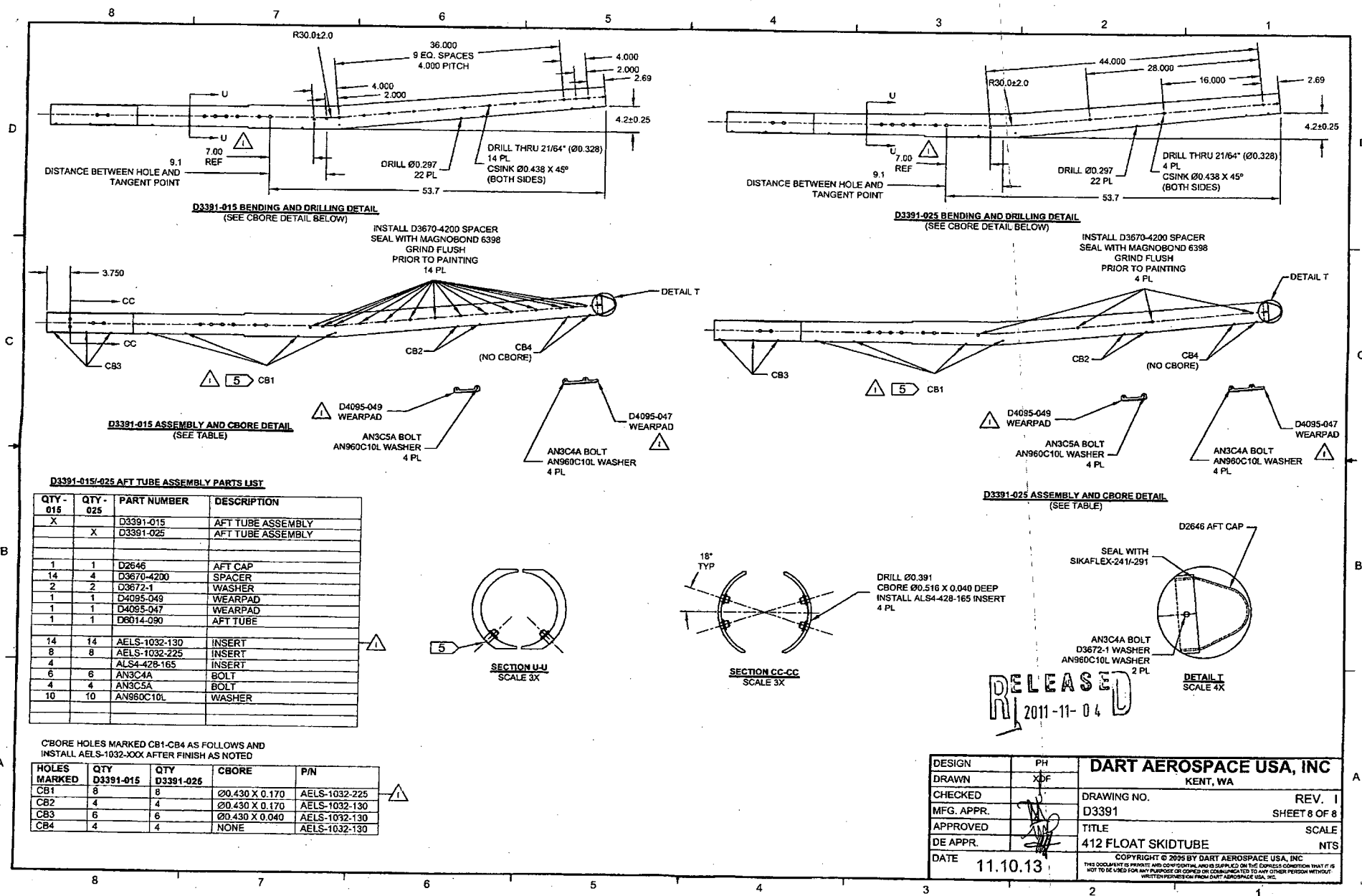
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DART AEROSPACE LTD		Work Order:	80281
Description: Float Skidtube (412)		Part Number:	D3391-3
Inspection Dwg: D3391	Rev: H F	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.00	✓		tape	mm L-02
3.500	+/-0.010	3.499	✓		vern	cnc-08
88.93	+/-0.030	88.93	✓		tape	mm L-02
Ø3.200	+/-0.010	3.197	✓		vern	cnc-08
88.93	+/-0.030	88.93	✓		tape	mm L-02
Ø3.750	+/-0.010	3.750	✓		vern	cnc-08
30° x 160° chamfer	+/-0.010	30x160	✓		"	

Measured by: Mmm.L	Date: 12/03/17
Audited by: H	Date: 12/05/24

HAAS Section						
1.526	+0.000/-0.030	1.506	-		Caliper	BC 02
7.500	+/-0.010	7.501	✓			"
27.750	+/-0.010	27.751	✓		Tape	BC 09
31.750	+/-0.010	31.751	✓			"
35.250	+/-0.010	35.251	✓			"
3.300	+/-0.010	3.305	✓			BC 07
0.200	+/-0.010	.195	✓			"
3.520	+/-0.010	3.521	✓			"
0.687	+0.010/-0.000	.687	✓			"
R0.062	+/-0.010	.062	✓			"
Ø0.484	+0.005/-0.001	.484	✓			"

Measured by: H	Date: 12/03/24
Audited by: H-A	Date: 12/03/26

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	

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